



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-636-012
Job Sheet 180131



Part No: D350-636-012

Job Qty: 1 ea

Part Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 7/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3492 REV E SHEET 1, D2750-042 REV G SHEETS 1,2,5,9 IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	7/26/18	7/26/18	0.00	0.00	Start Up Skidtubes-1		JLM
110	Skidtubes	1 pcs	7/26/18	7/26/18	0.00	4.36	Skidtubes-4		BE DAS 38 9-89 38
120	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC10		
130	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		
140	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.91	HandFinish1		DR 18-08-23
150	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC7-2		
160	Skidtubes	1 pcs	7/26/18	7/26/18	0.00	4.36	Skidtubes-1		BE
170	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC10		DR 18-08-23
180	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		DR 18-08-23
190	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.91	HandFinish2		SA 18-08-23
200	SprayPaint	1 pcs	7/26/18	7/26/18	0.00	0.69	Spray Paint	AUG 7 7 2018	DAS 13 9-89
205	Outsource	1 pcs	7/26/18	7/26/18			ATE003-VC		PLO 40858 DAS 38
210	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC14		AUG 2 9 2018
230	HandFinish	1 pcs	7/26/18	7/26/18	0.00	0.91	HandFinish4		414-00-522 DAS 68
240	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC5		AUG 3 0 2018
250	Packaging	1 pcs	7/26/18	7/26/18	0.00	0.00	Packaging1-3		AUG 30 2018 9-89
260	QC	1 pcs	7/26/18	7/26/18	0.00	0.00	QC4		BB 69 DAS 9-89 69
270	Packaging	1 pcs	7/26/18	7/26/18	0.00	0.00	Packaging3-1		BB 9-89 69
275	DC	1 pcs	7/26/18	7/26/18	0.00	0.00	DC		BB 9-89 69
280	QC21-FG	1 Ea	7/26/18	7/26/18	0.00	0.00	QC21		BB 9-89 69

Part Op 110 - 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & Descriptions: DT8863A for second side only DT8863B for first side (detail K) 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

160 - 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 58874 exp. date: 18/06/08**ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use as is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Cross tube ☐ Small Fab ☐ Finishing composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other ☐	
Date :				MRB (QSI042) Approval	
		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

DART AEROSPACE
 Container No: S100548
 Part: D350-636-012
 Job No: 180131
 Serial No/Batch: S1005
 Revision: _____
 Inspector: _____
 Exp Date: _____
 Instructions: TC STC SH99-7

Environment _____ Design _____ Doc/D _____ Equip/Tooling _____ Handling/Pre _____ Material _____ Internal Transport _____ Tribal Knowledge _____ LOA _____ Substation _____ Past Expiry Date _____ Misidentified _____	Supplier _____ Training _____ Use for Testing _____ Poor Information _____ Rushing _____ Product Improvement _____ Process Improvement _____ Manufacturing Process _____ Past Due _____	Centre not Concentric _____ Cracks _____ Crimp/Kink/Ripple/Wave _____ Cuffs _____ Crushing _____ Heat Treat _____ Wave/Twist in Tube _____ Marks/Chatter _____	BOM/Route _____ Broken/Damage/Defect _____ Inspection Incomplete/Unqualified _____ Contamination _____ Countersink _____ Cut Too Short _____ Instructions Incomplete/Unclear _____ Drill Holes _____	CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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OTHER : _____

and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 138884 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____

210 - Inspect for foreign object per QSI 024

230 - 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: M138871 EXP DATE: 19106

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: M138847 5-Coat all exposed fasteners with "LPS Procyon" batch: M133646

270 - Package as per PPP D350-636-012

275 - record fwd angle: 89.8' Photocopy blue file and type labels per PPP D350-636-012 CHG 007

Job BOM

005223

Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-RH	Extrusion Bent RH	1 Ea (1 ea)	90-Start up Operation	5081485
D2744	Cap	1 Ea (1 ea)	110-Skidtubes	5060499
D2739	350 I-Beam	1 Ea (1 ea)	160-Skidtubes	5080843
D2743	Crossbolt Spacer	8 Ea (8 ea)	160-Skidtubes	5090612
D3490-1	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5082748
D3490-3	Cross Bolt Spacer	4 Ea (4 ea)	160-Skidtubes	5082750
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-HandFinish	5058138
AN3C5A	Bolt	34 Ea (34 ea)	230-HandFinish	5095214
AN3C6A	Bolt	4 Ea (4 ea)	230-HandFinish	5076000
AN6C44A	Bolt	4 Ea (4 ea)	230-HandFinish	5006333-1
AN8C35A	Bolt	1 Ea (1 ea)	230-HandFinish	F1137263
D2745	Bushing	8 Ea (8 ea)	230-HandFinish	5091812
D3488-042	Blade Fitting RH	1 Ea (1 ea)	230-HandFinish	5093466
D3492-1	Plug	8 Ea (8 ea)	230-HandFinish	5077552
D3492-3	Plug	8 Ea (8 ea)	230-HandFinish	5091840
D3535-25	Wearplate Center	1 Ea (1 ea)	230-HandFinish	5082030
D3536-25	Gasket Center	1 Ea (1 ea)	230-HandFinish	5099641
D3537-1	Wearpad	3 Ea (3 ea)	230-HandFinish	5083401
D3631-1	Washer	8 Ea (8 ea)	230-HandFinish	5052402
D3791-1	Wearpad	1 Ea (1 ea)	230-HandFinish	5081690
D3793-1	Wearplate Fwd	1 Ea (1 ea)	230-HandFinish	5089345
D3793-3	Wearplate Aft	1 Ea (1 ea)	230-HandFinish	5089416
D3794-1	Gasket Fwd	1 Ea (1 ea)	230-HandFinish	5071975
D3794-3	Gasket Aft	1 Ea (1 ea)	230-HandFinish	5081730
MS21043-6	Nut	4 Ea (4 ea)	230-HandFinish	5083545
MS21083C8	Nut	1 Ea (1 ea)	230-HandFinish	5090633
NAS1149C0332R	Washer	38 Ea (38 ea)	230-HandFinish	5071663
NAS1149C0832R	Washer	1 Ea (1 ea)	230-HandFinish	M138409-121
NAS1515H3L	Washer	4 Ea (4 ea)	230-HandFinish	5083539
NAS1611-010	O-Ring	8 Ea (8 ea)	230-HandFinish	5092499
NAS1611-013	O-Ring	8 Ea (8 ea)	230-HandFinish	5083560
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging	5106744
D2741	Replacement Blade	1 Ea (1 ea)	250-Packaging	5082286
D3493-1	Washer	2 Ea (2 ea)	250-Packaging	5095455
D3532-1	Spacer	2 Ea (2 ea)	250-Packaging	5090421
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging	5083551
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging	5089248

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2600-3-BENT-RH	1	19	0
110-Skidtubes	D2744	1	60	0
160-Skidtubes	D2739	1	37	0
	D2743	8	87	0
	D3490-1	4	203	0
	D3490-3	4	130	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

230-HandFinish

ALS4-1032-225	38	4,225	0
AN3C5A	34	2,030	0
AN3C6A	4	392	0
AN6C44A	4	283	0
AN8C35A	1	46	0
D2745	8	85	0
D3488-042	1	6	0
D3492-1	8	248	0
D3492-3	8	79	0
D3535-25	1	43	0
D3536-25	1	41	0
D3537-1	3	209	0
D3631-1	8	803	0
D3791-1	1	37	0
D3793-1	1	11	0
D3793-3	1	11	0
D3794-1	1	37	0
D3794-3	1	43	0
MS21043-6	4	240	0
MS21083C8	1	133	0
NAS1149C0332R	38	5,107	0
NAS1149C0832R	1	438	0
NAS1515H3L	4	635	0
NAS1611-010	8	429	0
NAS1611-013	8	1,325	0
AN8C21A	2	106	0
D2741	1	115	0
D3493-1	2	27	0
D3532-1	2	10	0
MS21083C8	2	133	0
NAS1149D0863J	2	77	0

250-Packaging

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALST7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 180131 M15

180625

RELEASED
2013-08-13

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3; REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 8413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN AG-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.07.11		

DART AEROSPACE USA, INC.

KENT, WA

DRAWING NO.

D2750

REV. G

SHEET 1 OF 11

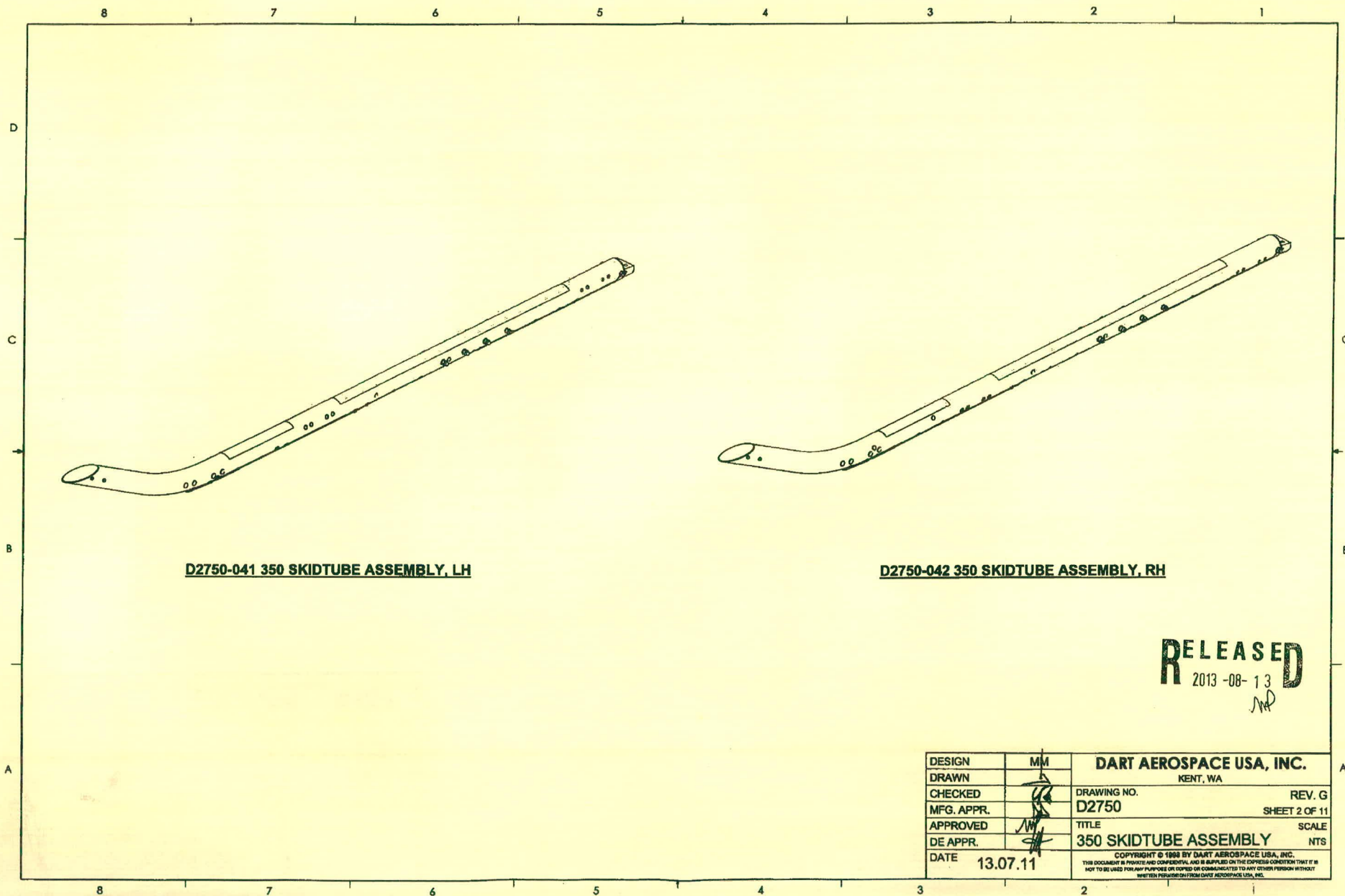
TITLE

350 SKIDTUBE ASSEMBLY

SCALE

NTS

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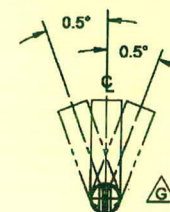
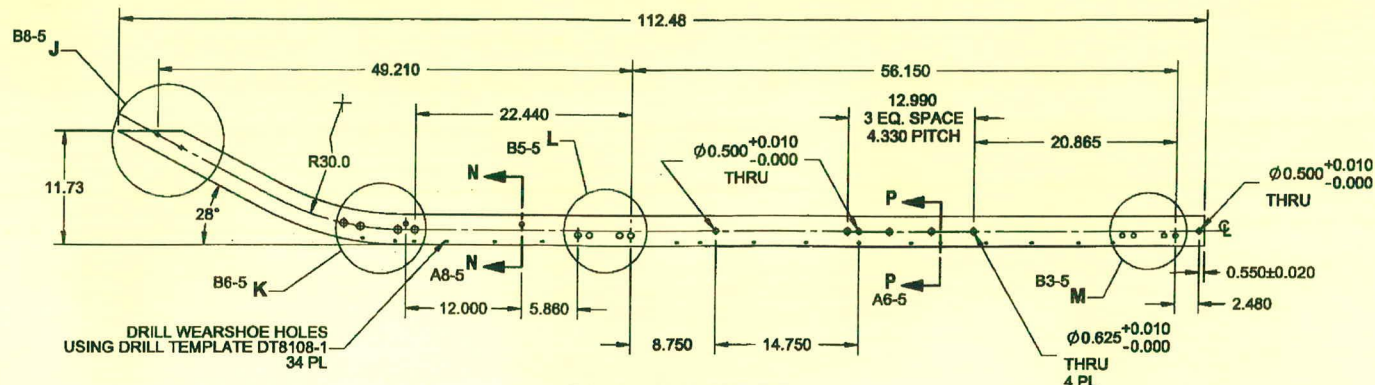


D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

RELEASED
2013-08-13
ND

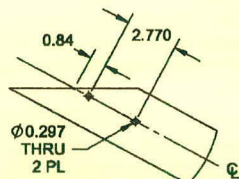
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	REV. G
MFG. APPR.		SHEET 2 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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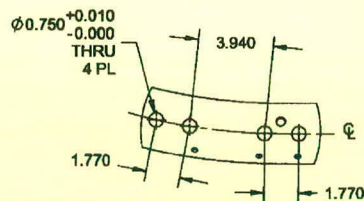
OUTBD

MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

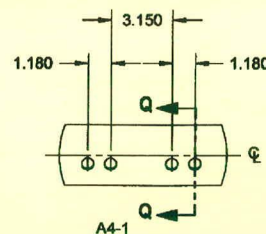
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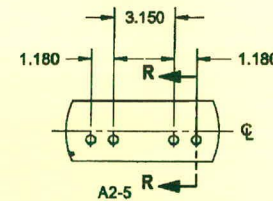
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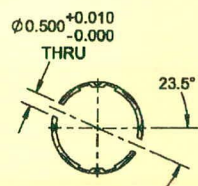
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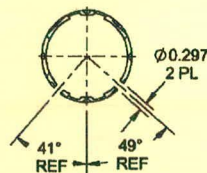
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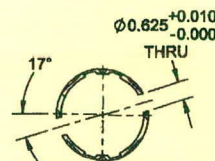
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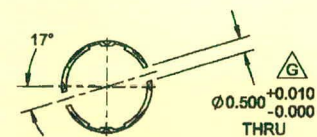
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN		MM		DART AEROSPACE USA, INC.	
DRAWN		[Signature]		KENT, WA	
CHECKED		[Signature]		DRAWING NO. D2750	
MFG. APPR.		[Signature]		REV. G	
APPROVED		[Signature]		SHEET 5 OF 11	
DE APPR.		[Signature]		TITLE	
DATE		13.07.11		350 SKIDTUBE ASSEMBLY	
				SCALE	
				NTS	

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2013-08-13

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
*20A	4	4	4	4		AN960C10L	WASHER (REPLACES AN960JD10)
*20B	4	4	4	4		NAS1515H3L	WASHER (REPLACES AN960JD10)
*22	5	5	5	5	5	D3537-1	WEARPAD (REPLACES D2648-3)
*23A	1	1	1	1	1	D3535-13	WEARSHOE (REPLACES D2656-13)
*23B	1	1	1	1	1	D3536-13	GASKET
*24A	1	1	1	1	1	D3535-25	WEARSHOE (REPLACES D2746)
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3535-35	WEARSHOE (REPLACES D2656-35)
*25B	1	1	1	1	1	D3536-35	GASKET
*26A	38	38	38	38	38	AN3C5A	BOLT (REPLACES AN3-5A)
*26B	4	4	4	4	4	AN3C7A	BOLT (REPLACES AN3-7A)
*27	42	42	42	42	42	AN960C10L	WASHER (REPLACES AN960JD10)
*28	38	38	38	38		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
***43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

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Revision: J

Date: 13.03.01

5.0 PARTS LIST (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 003)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -043	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-043	WEARSHOE KIT (REPLACES -041 KIT)
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT (REPLACES AN8-35A)
*6A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
*6B	2	2	2	2		NAS1515H8L	WASHER
*7	1	1	1	1		MS21083C8	NUT (REPLACES MS21083N8)
*8	1		1			D3488-041	BLADE FITTING, LH (REPLACES D2742-1)
*8		1		1		D3488-042	BLADE FITTING, RH (REPLACES D2742-2)
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT (REPLACES AN8-16A)
11A	2	2	2	2		AN960C816L	WASHER (REPLACES AN960JD816)
11B	2	2	2	2		D3672-13	WASHER
12	2	2	2	2		MS21083C8	NUT (REPLACES MS21083N8)
*13	4	4	4	4		ALS4-1032-225	INSERT
*14	4	4	4	4		AN6C44A	BOLT (REPLACES AN6-44A)
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT (REPLACES MS21042L6)
*17	8	8	8	8		D3631-1	WASHER (REPLACES NAS1515H8L)
*18	4	4	4	4		ALS4-1032-225	INSERT (REPLACES NAS1330S3KB166)
*19	4	4	4	4		AN3C6A	BOLT (REPLACES AN3-6A)

(CONTINUED ON NEXT PAGE)

REFERENCE ONLY

